



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D3278-2
Job Sheet 173655



Part No: D3278-2

Job Qty: 40 ea

Part Name: Support



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 3/9/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C IPP: A 04.04.19 New issue KJ/JLM IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea		3/7/18	0.00	0.00	Start Up Machining-2		18-03-07
100	Bandsaw	40 pcs		3/8/18	0.00	2.00	Bandsaw1		18-03-10
110	CNC Vertical Machining	40 pcs		3/8/18	0.06	17.17	HAAS 5 Axis		18-03-10
120	Outsource	40 pcs		3/8/18	0.00	0.00	Outsource		18-03-13
130	QC	40 pcs		3/8/18	0.00	0.00	QC8 Machining-2		18-03-13
140	HandFinish	40 pcs		3/8/18	0.00	4.12	HandFinish1		18-03-13
150	Powdercoat	40 pcs		3/9/18	0.00	0.82	Powdercoat1		18-03-19
160	QC	40 pcs		3/9/18	0.00	0.00	QC3		18-03-19
170	Packaging	40 pcs		3/9/18	0.00	0.00	Packaging3-1		18-03-19
180	QC21-SA	40 Ea		3/9/18	0.00	0.00	QC21		18-03-19

Part Op 100 - Cut blank: 2.00" x 1.00" x 2.550" long

Descriptions: 150 - START TIME: 11:05 AM 3/8/18

170 - LOCATION: GA

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X02.000	6061-T6 Bar 1.00 X 2.00	9.3480 ft (.2337 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X02.000	9	51	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By _____	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



Container No: 8048866



Part: D3278-2

Job No: 173655

Serial No/Batch: 8048866

Revision:

Inspector:

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www.dartaerospace.com

Date: 03/07/18

elle.linda

Part Specifications				
Spec No	Description	Target/Tolerance	Limits	Type
1	Support	0.098inches + 0.005 - 0.000	0.103 0.098	0.100
2	Support	0.359inches ± 0.005	0.364 0.354	0.5025
3	Support	0.609inches ± 0.010	0.619 0.599	0.612
4	Support	0.250inches ± 0.010	0.260 0.240	0.253
5	Support	1.480inches ± 0.005	1.485 1.475	1.480
6	Support	0.125inches ± 0.010	0.135 0.115	0.5
7	Support	0.119inches + 0.005 - 0.004	0.124 0.115	0.5
8	Support	2.439inches ± 0.010	2.449 2.429	2.442
9	Support	1.980inches ± 0.010	1.990 1.970	1.982
10	Support	0.130inches ± 0.030	0.160 0.100	0.125
11	Support	0.257inches + 0.005 - 0.000	0.262 0.257	0.258
12	Support	0.375inches ± 0.010	0.385 0.365	0.375
13	Support	0.875inches ± 0.010	0.885 0.865	0.875
14	Support	0.500inches ± 0.010	0.510 0.490	0.502
15	Support	0.400inches ± 0.010	0.410 0.390	0.400
16	Support	1.000inches ± 0.030	1.030 0.970	1.00
17	Support	1.720inches ± 0.010	1.730 1.710	1.722
18	Support	0.125inches ± 0.010	0.135 0.115	0.130
19	Support	0.125inches ± 0.010	0.135 0.115	0.125

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS				
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			